



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-A-01
Job Sheet 173874



Part No: RBE350A94-3700-A-01

Job Qty: 18 ea

Part Name: Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 3/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea		3/30/18	0.00	0.00	Start Up Machining-4		18-6-8
110	CNC Lathe	18 pcs		3/31/18	0.00	4.50	MORI SL-154		18-6-8
120	QC	18 pcs		3/31/18	0.00	0.00	QC2		18-6-8
130	QC	18 pcs		3/31/18	0.00	0.00	QC8		18-6-8
135	HandFinish	18 pcs		3/31/18	0.00	1.80	HandFinish7		18-6-8
150	Outsource	18 pcs		3/31/18	0.00	0.00	Outsource12		18-6-8
160	Packaging	18 pcs		3/31/18	0.00	0.00	Packaging2		18-6-8
170	QC	18 pcs		3/31/18	0.00	0.00	QC6		18-6-8
180	Packaging	18 pcs		3/31/18	0.00	0.00	Packaging3		18-6-8
210	QC21-SA	18 Ea		3/31/18	0.00	0.00			18-6-8

Part Op 110 - 1-Machine as per FOLIO FB780 FOLIO REV: AA DWG REV: 7 2-Debur 3-Engrave T/N

Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.

135 - Bead blast

150 - Issue P/O to Groupe Altech; PO 040175 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-0.750W0.085	A513 Seamless Alloy Steel Round Tubing 0.75"dia. x 0.085" Wall	19.8000 ft (1.1 ea)	90-Start up Operation	S053643

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-A513-T-0.750W0.085	20	2	0

ifications

ould not be found.

Plex 3/8/18 7:55 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S079191



Part: RBE350A94-3700-A-01

Job No: 173874

Serial No/Batch: S079191

Revision: 7

Inspector:

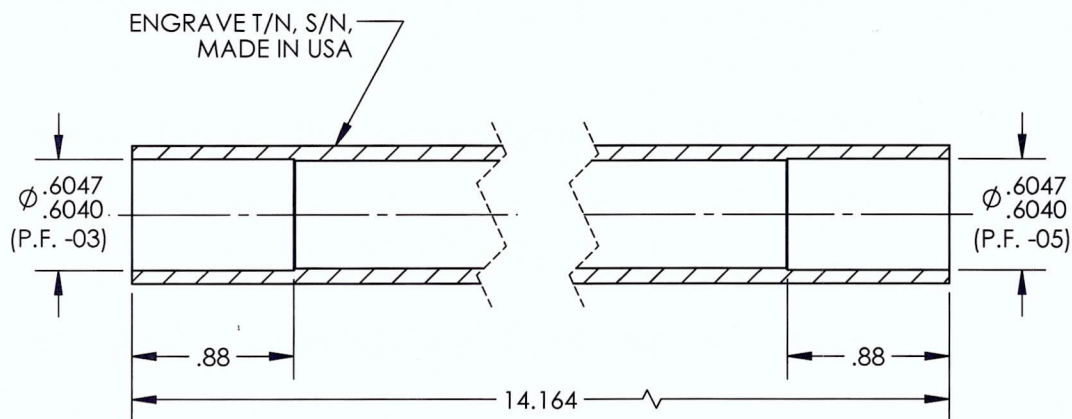
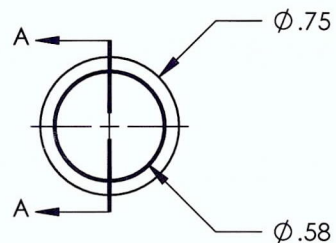
Exp Date: 06/08/2018

Instructions:

Date: 06/08/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	15-0212	-01 CH'D OAL WAS 14.173 IS 14.164. ADDED ENGRAVE NOTE.	8/14/2015	RJC	JAG
7	16-0282	-01 ADDED DIMS Ø.6040-.6047 (P.F. -03), .88, Ø.6040-.6047 (P.F. -05), .88. ADDED FINISH BLACK OXIDE QMSI-6.2.2, B.O. REV D. CH'D MAT'L WAS STEEL IS DOM.	1/3/2017	DPD	JAG



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173874
20180501

(01)
TUBE

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
DWG NO. RBE350A94-3700-A-01	REV 7
MAT'L DOM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012 SHEET 3 OF 5



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040175

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040175
PO Date: 6/14/18
Due Date: 6/18/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173874	RBE350A94-3700-A-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/15/18	24 pcs	0 pcs	24 pcs	\$3.85/pcs	\$92.40
2	173878	RBE350A94-3700-C-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/15/18	28 pcs	0 pcs	28 pcs	\$1.80/pcs	\$50.40

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Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	178864	RBW6420G00131-8G-5	Pin -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Material type 4140 -Certificate of Conformity is required -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Material type 4140 -Certificate of Conformity is required -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Material type 4140 -Certificate of Conformity is required	Firmed	6/15/18	12 pcs	0 pcs	12 pcs	\$12.50/pcs	\$150.00
4	177002	RB877406-5-27	Bolt -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	6/15/18	10 pcs	0 pcs	10 pcs	\$0.97/pcs	\$9.70
5	173926	RBE703A94-1130-01-09	Bottom Fixture 2 -Issue P/O to Groupe Altech: PO _____-ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2 WATER SEALANT -Certificate of Conformity is required	Firmed	6/15/18	12 pcs	0 pcs	12 pcs	\$4.95/pcs	\$59.40
6	173876	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/15/18	21 pcs	0 pcs	21 pcs	\$2.80/pcs	\$58.80
7	177001	RB877406-5-21	Cap -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/15/18	13 pcs	0 pcs	13 pcs	\$1.15/pcs	\$14.95

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	177060	RBW6420G01531-8G-2	Guide -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	6/18/18	6 pcs	0 pcs	6 pcs	\$1.05/pcs	\$6.30
9	173859	RBE350A93-3307-00-01	Retractor -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	6/18/18	12 pcs	0 pcs	12 pcs	\$2.55/pcs	\$30.60
10	177059	RBW6420G01531-8G-1	Reaction -Issue P/O to ATG: _____ - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	6/18/18	6 pcs	0 pcs	6 pcs	\$10.00/pcs	\$60.00
11	178821	RBW6505G00831-3G-23	Bar -Issue P/O to ATG: _____ - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	6/18/18	6 pcs	0 pcs	6 pcs	\$2.25/pcs	\$13.50

18.06.20 inv.

6x 18.06.22 inv.

6x 18.06.22 inv.

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
12	176957	C3-11-1	Side Plate - Solenoid C3-Hook -Issue P/O to Groupe Altech : -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/18/18	19 pcs	0 pcs	19 pcs	\$6.55/pcs	\$124.45
13	177000	RB877406-5-17	R & I Adapter -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	6/18/18	11 pcs	0 pcs	11 pcs	\$1.25/pcs	\$13.75
Grand Total:										\$684.25
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retension of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 6/18/18 4:10 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(010350-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010350 - 3

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
29-Jun-2018		Aman		PO040175				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-A-01 Rev.	RBE350A94-3700-A-01 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	24	24	0	0	0
2	RBE350A94-3700-C-01 Rev.	RBE350A94-3700-C-01 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	28	28	0	0	0
4	RB877406-5-27 Rev.	RB877406-5-27 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	BLACK-OXIDE CH	10	10	0	0	0
6	RBE350A94-3700-A-05 Rev.	RBE350A94-3700-A-05 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	21	21	0	0	0
10	RBE350A93-3307-00-01 Rev.	RBE350A93-3307-00-01 01-OXIDE BLACK [OXIDE BLACK] MIL-C13964 CLASS 1, MIL-C-16173 GRADE 4	OXIDE-BLACK CH	12	12	0	0	0
14	RB877406-5-17 Rev.	RB877406-5-17 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS.	OXIDE-BLACK CH	11	11	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.